

Work Order ID 57754

April 14, 2010 11:39:06 AM



Page 1

Item ID: D3208-9

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 4/14/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/19/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3208

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3208 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-
Deburr if necessary

2024 . 080

AB 10-5-6

15

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AB 10-5-6

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sokolov

[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57754

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Page 2

Item ID: D3208-9

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Start Date: 4/14/10 Start Qty: 6.00



Cust Item ID:

Required Date: 4/19/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Small Fab

Memo
Debur

alas

0.00

Small Fab

Small Fab

140

0.00



Chemical Conversion Coat per QSI005 4.1

Memo

0.00

HandFinish

Hand Finishing

= 7 m-l 10/05/07

15X

150

0.00



QC3- Inspect Part Finish

Memo

0.00

QC

Quality Control

15 10/05/07

15 Ø

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57754

April 14, 2010 11:39:07 AM



Page 3

Item ID: D3208-9

Accept



Setup Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 4/14/10

Start Qty: 6.00



Cust Item ID:

Required Date: 4/19/10

Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: 22

0.00

Memo

0.00

Packaging

10/05/10 (15)

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

10/05/10 15
BS 10-5-10
15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 14, 2010 11:39:05 AM

Page 1

Work Order ID: 57754



Parent Item: D3208-9



Parent Item Name: Doubler

Start Date: 4/14/10

Required Date: 4/19/10

Comments: IPP A 04.06.09 New issue KJ/RF

Start Qty: 6.00

Required Qty: 6.00

IPP Rev:B Now on Waterjet 07-08-29 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	162.0000	0.9120	2.3		



2024-T3 .080 sheet

18 10-5-6

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT22

162

104921

2

105411

7

112331

3

113796

36

114025

114

113796

15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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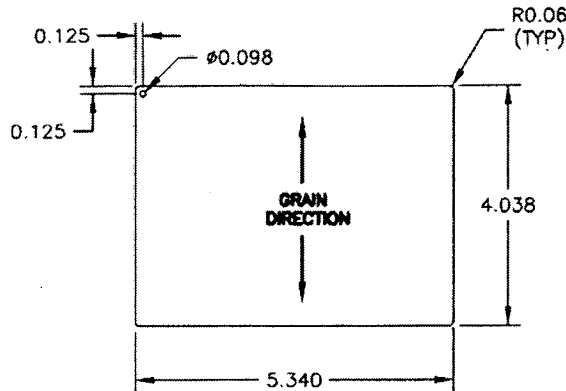
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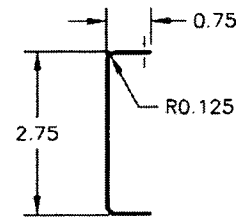
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CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3

RELEASED
04 04 05

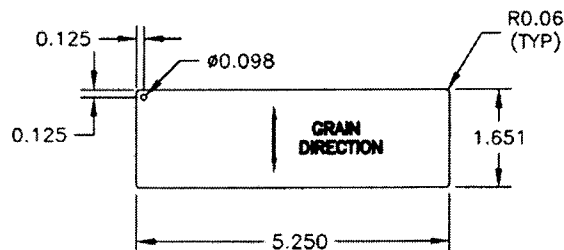
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04.01.25 04.01.25 04.01.25 04.01.25 04.01.25



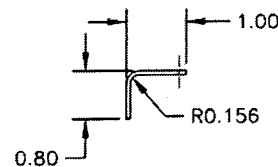
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.060" THICK (M2024T3S.060)

47754

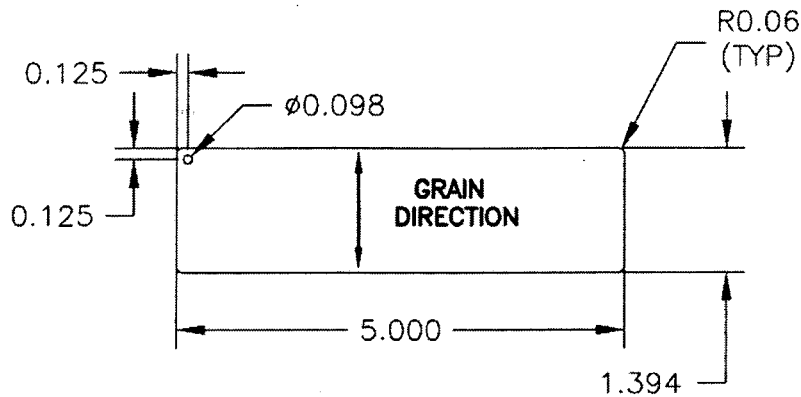
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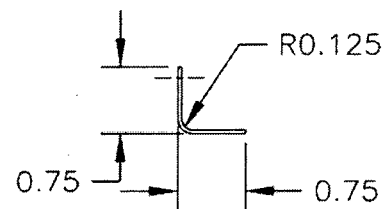


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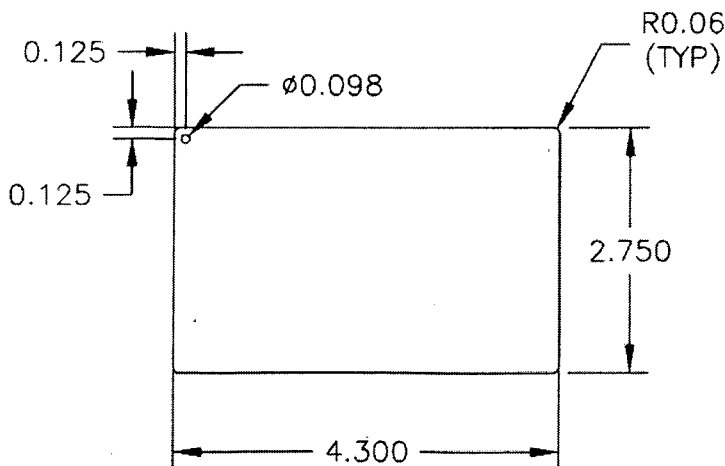
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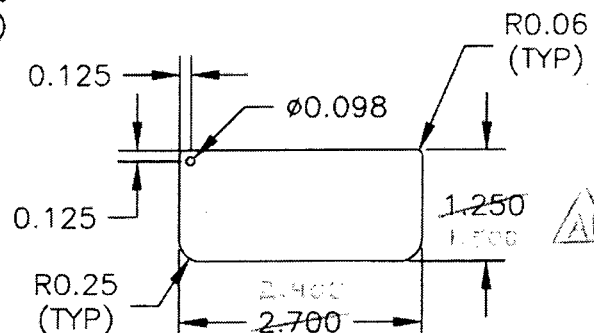
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

WLO 57754

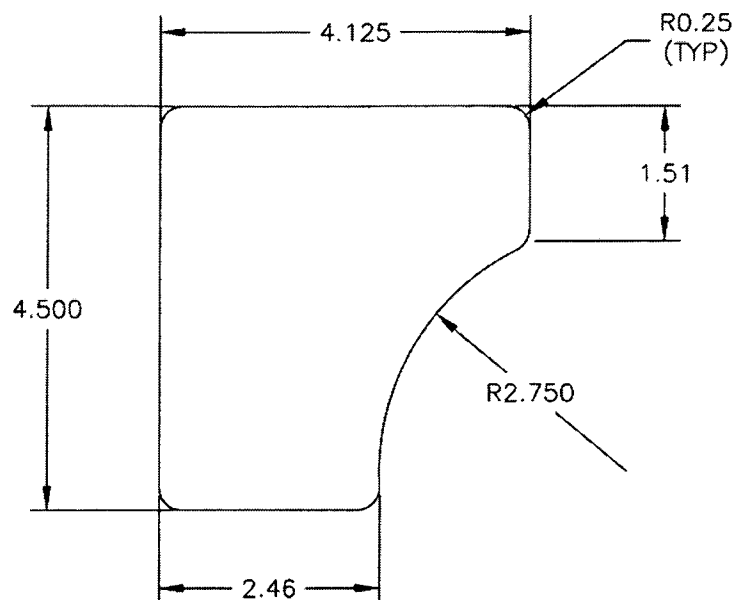
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CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

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04.04.05



D3208-9 DOUBLER

WLO 57754

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